WHAT IS CLAIMED IS:

1. A brandy replica comprising:

water,

a grain neutral spirit,

an oak extract, one or more tannins, or an oak extract and one or more tannins, and

at least six added volatile compounds (VOCs), wherein said added VOCs comprise at least one ester, at least one additional alcohol, at least one aldehyde or ketone, and at least one terpene or isoprenoid, and wherein said added VOCs comprise about 0.001 wt% to about 0.1 wt% of said brandy replica.

2. The brandy replica of claim 1, further comprising a traditional brandy, wherein said brandy replica comprises no more than about 10 wt% of said traditional brandy.

3. The brandy replica of claim 1 or claim 2, wherein said at least one ester comprises one or more of phenethyl acetate, ethyl laurate, ethyl acetate, tetrahydrofurfuryl acetate, butyl isobutyrate, ethyl butyrate, hexyl 2-methylbutanoate, isobutyl isobutyrate, isobutyl propionate, and propyl acetate.

4. The brandy replica of any one of claims 1 to 3, wherein said at least one aldehyde or ketone comprises one or more of phenylacetaldehyde, 2,3-pentanedione, 2-heptanone, and methylcyclopentenolone.

5. The brandy replica of any one of claims 1 to 4, wherein said at least one additional alcohol comprises one or both of isoamyl alcohol and phenethyl alcohol.

6. The brandy replica of any one of claims 1 to 5, wherein said at least one terpene or isoprenoid comprises linalool.

7. The brandy replica of any one of claims 1 to 6, wherein said added VOCs further comprise at least one furan, at least one acid, at least one phenol, or a combination thereof.

8. The brandy replica of claim 7, wherein said at least one furan comprises 2-pentylfuran, wherein said at least one acid comprises butyric acid, and wherein said at least one phenol comprises eugenol.

9. The brandy replica of claim 1, wherein said added VOCs comprise ethyl laurate, phenethyl alcohol, 2-pentylfuran, linalool, 2,3-pentanedione, eugenol, ethyl acetate, phenethyl acetate, phenylacetaldehyde, tetrahydrofurfuryl acetate, and methylcyclopentenolone.

10. The brandy replica of claim 1, wherein said added VOCs comprise propyl acetate, ethyl butyrate, isobutyl isobutyrate, hexyl 2-methylbutanoate, butyl isobutyrate, 2-heptanone, linalool, butyric acid, isoamyl alcohol, and isobutyl propionate.

11. The brandy replica of any one of claims 1 to 10, further comprising at least one added non-volatile compound.

12. The brandy replica of claim 11, wherein said at least one added non-volatile compound comprises a color compound.

13. The brandy replica of claim 11, wherein said at least one added non-volatile compound is selected from the group consisting of 2-mercapto-4,6-dimethylnicotinonitrile, 4,4-dihydroxybenzophenone, 4-methyl-2,3-dihydro-1h-pyrrolo[3,4-c]-quinoline, azobenzene, carnosine, choline, betaine, trigonelline, pyridoxal, nicotinic acid, furaneol, 2,3-isopropylidene-d-ribonolactone, 3-methylglutaric acid, homovanillic acid, fraxetin, coniferyl aldehyde, cyclohexyl thiourea, cyanazine, dimethyl phthalate, isophorone, 2,6-dimethyl-gamma-pyrone, vanillin, quinic acid, gallic acid, isoferulic acid, scopoletin, ethyl paraben, 3-hydroxypyridine, mannitol, mannoheptulose, trehalose, 3-hydroxy-2-methylpyridine, diglycerol, 1-(2-hydroxyethyl)-2-imidazolidenethione, and 2-aminobenzothiazole.

14. The brandy replica of any one of claims 1 to 13, comprising:
from about 5 wt% to about 70 wt% water,
from about 30 wt% to about 95 wt% grain neutral spirits,

from about 0.5 wt% to about 10 wt% traditional brandy,

from about 0.1 wt% to about 10 wt% oak extract,

from about 0.001 wt% to about 1 wt% tannins,

from about 0.01 wt% to about 1 wt% color, and

from about 0.001 wt% to about 0.1 wt% added VOCs.

15. A method for making a brandy replica, wherein said method comprises combining:

water,

a grain neutral spirit,

an oak extract, a tannin, or an oak extract and a tannin,

at least six VOCs, wherein said VOCs are provided as separate ingredients and comprise at least one ester, at least one additional alcohol, at least one aldehyde or ketone, and at least one terpene or isoprenoid, and wherein said added VOCs comprise about 0.001 wt% to about 0.1 wt% of said brandy replica, and

optionally, a traditional brandy, such that said brandy replica comprises no more than about 10 wt% of said traditional brandy.

16. The method of claim 15, wherein said at least one ester comprises one or more of phenethyl acetate, ethyl laurate, ethyl acetate, tetrahydrofurfuryl acetate, butyl isobutyrate, ethyl butyrate, hexyl 2-methylbutanoate, isobutyl isobutyrate, isobutyl propionate, and propyl acetate.

17. The method of claim 15 or claim 17, wherein said at least one aldehyde or ketone comprises one or more of phenylacetaldehyde, 2,3-pentanedione, 2-heptanone, and methylcyclopentenolone.

18. The method of any one of claims 15 to 17, wherein said at least one additional alcohol comprises one or both of isoamyl alcohol and phenethyl alcohol.

19. The method of any one of claims 15 to 18, wherein said at least one terpene or isoprenoid comprises linalool.

20. The method of any one of claims 15 to 19, wherein said added VOCs further comprise at least one furan, at least one acid, at least one phenol, or a combination thereof.

21. The method of claim 20, wherein said at least one furan comprises 2-pentylfuran, wherein said at least one acid comprises butyric acid, and wherein said at least one phenol comprises eugenol.

22. The method of claim 15, wherein said added VOCs comprise ethyl laurate, phenethyl alcohol, 2-pentylfuran, linalool, 2,3-pentanedione, eugenol, ethyl acetate, phenethyl acetate, phenylacetaldehyde, tetrahydrofurfuryl acetate, and methylcyclopentenolone.

23. The method of claim 15, wherein said added VOCs comprise propyl acetate, ethyl butyrate, isobutyl isobutyrate, hexyl 2-methylbutanoate, butyl isobutyrate, 2-heptanone, linalool, butyric acid, isoamyl alcohol, and isobutyl propionate.

24. The method of any one of claims 15 to 23, further comprising combining at least one added non-volatile compound with said water, grain neutral spirit, oak extract and/or tannin, at least six VOCs, and optional traditional brandy.

25. The method of claim 24, wherein said at least one added non-volatile compound comprises a color compound.

26. The method of claim 24, wherein said at least one added non-volatile compound is selected from the group consisting of 2-mercapto-4,6-dimethylnicotinonitrile, 4,4-dihydroxybenzophenone, 4-methyl-2,3-dihydro-1h-pyrrolo[3,4-c]-quinoline, azobenzene, carnosine, choline, betaine, trigonelline, pyridoxal, nicotinic acid, furaneol, 2,3-isopropylidene-d-ribonolactone, 3-methylglutaric acid, homovanillic acid, fraxetin, coniferyl aldehyde, cyclohexyl thiourea, cyanazine, dimethyl phthalate, isophorone, 2,6-dimethyl-gamma-pyrone, vanillin, quinic acid, gallic acid, isoferulic acid, scopoletin, ethyl paraben, 3-hydroxypyridine, mannitol, mannoheptulose, trehalose, 3-hydroxy-2-

methylpyridine, diglycerol, 1-(2-hydroxyethyl)-2-imidazolidenethione, and 2-aminobenzothiazole.

27. The method of any one of claims 15 to 26, wherein said brandy replica comprises:
from about 5 wt% to about 70 wt% water,
from about 30 wt% to about 95 wt% grain neutral spirits,
from about 0.5 wt% to about 10 wt% traditional brandy,
from about 0.1 wt% to about 10 wt% oak extract,
from about 0.001 wt% to about 1 wt% tannins,
from about 0.01 wt% to about 1 wt% color, and
from about 0.001 wt% to about 0.1 wt% added VOCs.

28. A brandy replica produced by the method of any one of claims 15 to 27.

29. A brandy-like alcoholic beverage concentrate comprising:
an oak extract,
tannins,
at least six added VOCs, wherein said added VOCs comprise at least one ester, at least one additional alcohol, at least one aldehyde or ketone, and at least one terpene or isoprenoid, and wherein at least one of said added VOCs is present in a concentration of at least about 2-fold the concentration of the same VOC in a corresponding traditional brandy, and
optionally, a traditional brandy, wherein said alcoholic beverage, after dilution to produce a final product, comprises no more than about 10 wt% of said traditional brandy.

30. The brandy-like alcoholic beverage concentrate of claim 29, wherein at least one of said added VOCs is present in the concentrate in a concentration of at least about 5-fold the concentration of the same VOCs in a corresponding traditional brandy.

31. The brandy-like alcoholic beverage concentrate of claim 29, wherein at least one of said added VOCs is present in the concentrate in a concentration of at least about 10-fold the concentration of the same VOCs in a corresponding traditional brandy.

32. The brandy-like alcoholic beverage concentrate of claim 29, wherein at least one of said added VOCs is present in the concentrate in a concentration of at least about 15-fold the concentration of the same VOCs in a corresponding traditional brandy.

33. The brandy-like alcoholic beverage of any one of claims 29 to 32, wherein upon dilution of said brandy-like beverage concentrate to a brandy-like alcoholic beverage, the brandy-like alcoholic beverage is the brandy replica of any one of claims 1 to 49.

34. A method of making a brandy-like alcoholic beverage concentrate, the method comprising combining:

an oak extract,

tannins,

at least six added VOCs, wherein said added VOCs comprise at least one ester, at least one additional alcohol, at least one aldehyde or ketone, and at least one terpene or isoprenoid, and wherein at least one of said added VOCs is present in a concentration of at least about 2-fold the concentration of the same VOC in a corresponding traditional brandy, and

optionally, a traditional brandy, wherein said alcoholic beverage, after dilution to produce a final product, comprises no more than about 10 wt% of said traditional brandy.

35. The method of claim 34, wherein at least one of said added VOCs is present in the concentrate in a concentration of at least about 5-fold the concentration of the same VOCs in a corresponding traditional brandy.

36. The method of claim 34, wherein at least one of said added VOCs is present in the concentrate in a concentration of at least about 10-fold the concentration of the same VOCs in a corresponding traditional brandy.

37. The method of claim 34, wherein at least one of said added VOCs is present in the concentrate in a concentration of at least about 15-fold the concentration of the same VOCs in a corresponding traditional brandy.

38. The method of any one of claims 34 to 37, wherein upon dilution of the brandy-like beverage concentrate to a brandy-like alcoholic beverage, the brandy-like alcoholic beverage is the brandy replica of any one of claims 1 to 14.